

Page 1

Stamp

June 22, 2010 2:32:21 PM Item ID: D4051-041 Accept Setup Start **Revision ID:** Stop Item Name: Rappel Deflector Assembly, LH Start Qty: 1.00 **Start Date:** 6/22/10 **Cust Item ID:** Required Date: 6/29/10 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Process Plan: Date: 106-27 Tooling: **Approvals:** Stop SPC (Y/N): QC: Date: Date: Sequence ID/ **Operation** Tool ID Tool # Plan Reject Accept Set Up/ **Work Center ID** Description Qty Code Qty Number **Run Hours Revision Nbr Draw Nbr** D4051 Weld per dwg A/R S.S. rod Batch Benice 1150.00 100 Large Fab 0.00 Memo Large Fab 1- Weld brackets, filler and mounting plate to bar using basket 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 0.00 Memo Quality Control 120 QC5- Inspect part completeness to step on W/O 0.00

Quality Control

QC

Memo

tel Fit in Basters

0.00

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W/O:			W	ORK ORDER CHANG	GES		,,			
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No										
	R	esolution:	PAR #: Fault Category: NCR: Yes No DQA: Date: tion: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) Description of NC Chief Eng / Prod Mgr / P	· · · · · · · · · · · · · · · · · · ·						
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DATE	STEP	Description of NC	Initial		tion B	Sian &				Approval
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June 22, 2010 2:32:21 PM

Required Date: 6/29/10

Item ID:

D4051-041

Accept

Setup Start

Stop

Revision ID:

Item Name:

Rappel Deflector Assembly, LH

Start Date:

6/22/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date: ____

Start Run

Reject

Qty

Date:

Tool # Plan

Code.

Stop

Number Stamp

Sequence ID/ Work Center ID

Powdercoat

Powder Coating

Operation **Description**

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

Oven Temperature: Finish Time: Set Up/ **Run Hours**

0.00

0.00

140

HandFinish

Hand Finishing

Memo

Install label as per dwg

0.00

0.00

Accept

Qty

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

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W/O:	•		WC	RK ORDER CHANG	ES				£
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		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date			Chief Eng	QC Inspector
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Work Order ID 59999

June 22, 2010 2:32:22 PM



Page 3

Item ID:

D4051-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Rappel Deflector Assembly, LH

Start Date:

6/22/10

Start Qty: 1.00

Req'd Qty: 1.00



Date:____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Start

Stop

Run



QC:

Sequence ID/

Required Date: 6/29/10

Work Center ID

160

Description

Operation

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code Accept Qty

Reject Oty:

Reject Insp. Number

Stamp

Quality Control

Packaging Packaging

170

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

0.00

180

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

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W/O:			WC	ORK ORDER CHANGE	S				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		ef Eng	QC Inspect
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June 22, 2010 2:32:20 PM

Work Order ID: 59999

Parent Item:

D4051-041

Parent Item Name: Rappel Deflector Assembly, LH



Start Date: 6/22/10

Required Date: 6/29/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 10.01.14 verified by:EC

Manufactured

Manufactured

dwg REV.A DD 10.02.22 verified by:EC

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per k	Kit Total Qty	Qty Issued	Date Status Issued
D4051-1 Rappel Deflector		Manufactured	No			100	Each	0.0000		1 8599	98 » (1000101 C
D4051-3 		Manufactured	No .			100	Each	1.0000	2	2 Bb022	3-50	N 10.07.06
				Location		Loca)tv	Loc Code	1			

IPP Rev:B as per

			Location	L	oc Qty	Loc Code	1	htc233 >
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D4051-5		X 1	56110	100	1 !		1	
	Manufactured	No		100	Each	1.0000		1
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Mounting Plate			Loodin		0.		ï	
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ar"		100	Each	3.0000
				1

<u>Location</u>	<u>Lo</u>	c Qty	Loc Code
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55997		3	
	140	Each	4.0000

<u>Location</u>	Loc Oty	Loc Code
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55272	4	

B60280 >0 PD 10.07.06

Placard

D4051-7

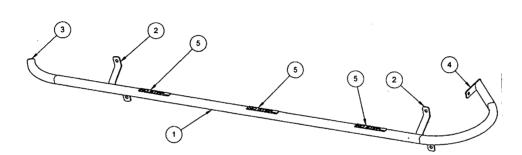
Filler

D4051-9

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W/O:			W	ORK ORDER CHANG	ES				
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QTY -041 QTY ITEM DESCRIPTION D4051-041 RAPPEL DEFLECTOR ASSY RAPPEL DEFLECTOR ASSY D4051-042 X D4051-1 RAPPEL DEFLECTOR 2 -2 2 D4051-3 BRACKET 1 D4051-Ź FILLER D4051-5 MOUNTING PLATE D4051-9 PLACARD



SHOP COPY RET PRN TO ENGINEERING UNCONTROLLED CO. SUBJECT TO AMENDM. WITHOUT NOTICE

WITHOUT NOTICE
WORK ORDER
NO. 59999

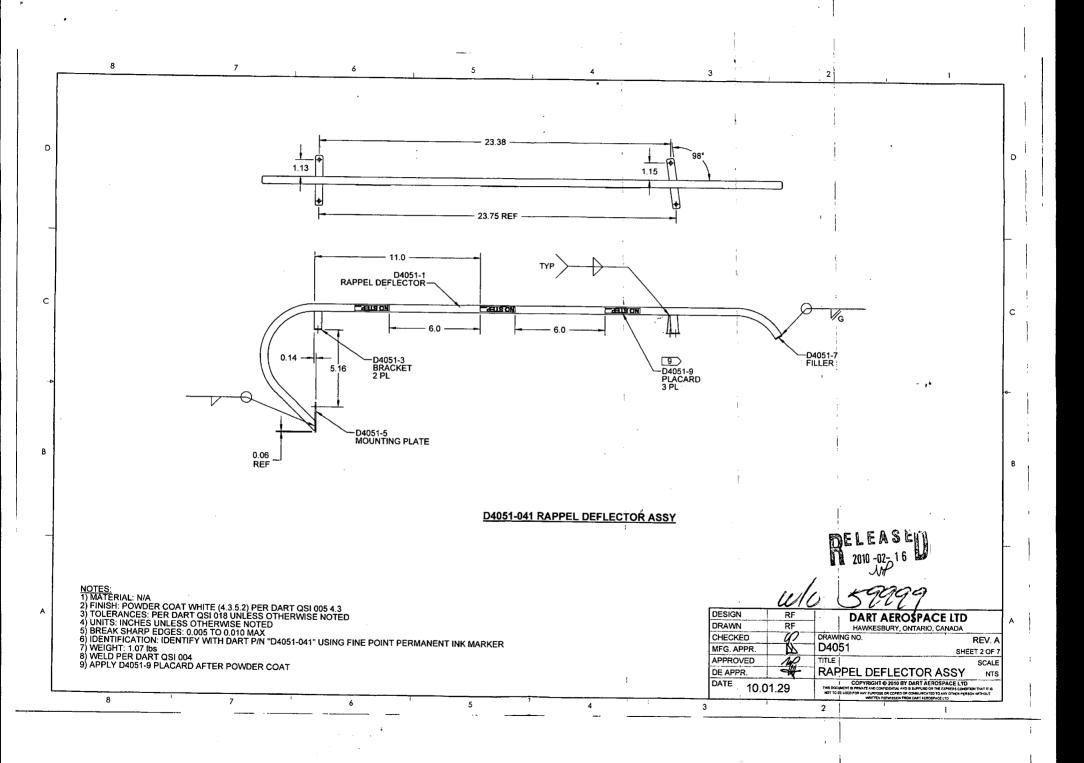
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D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN) D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE)

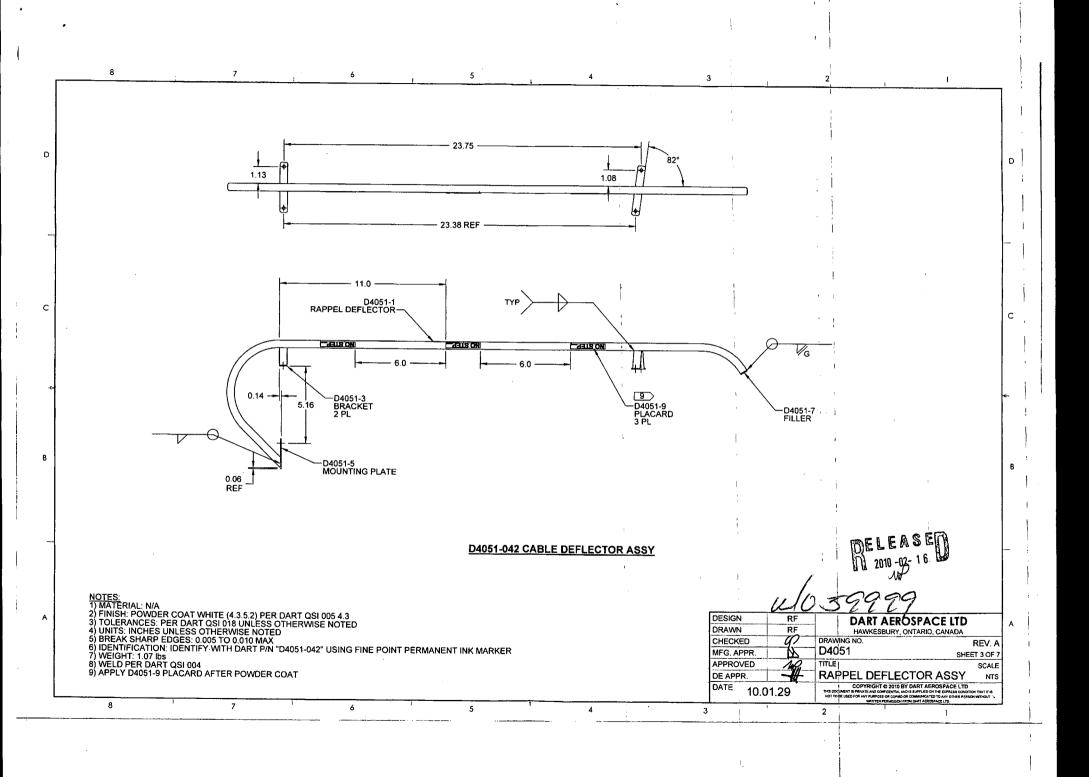
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MFG. A		7	D4051	SHEET 1 OF 7					
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28.00 ` 60° 135°±15° 2.00 CLR3.25 8.53

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8 D4051-1 RAPPEL DEFLECTOR

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.98 lbs
8) TUBE FLAT LENGTH 43.00 REF

RF

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA RF DRAWING NO. CHECKED REV. A D4051 MFG. APPR. SHEET 4 OF 7 APPROVED TITLE RAPPEL DEFLECTOR ASSY

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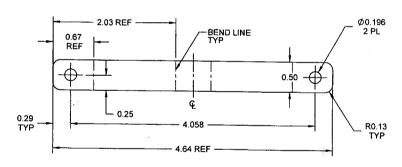
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0.63 --- 1.35 · R0.13 4 PL 1.24 0.060 REF 0.69 TYP - 3.33 REF -D4051-3 BRACKET (MAKE FROM D4051-3F FLAT PATTERN)



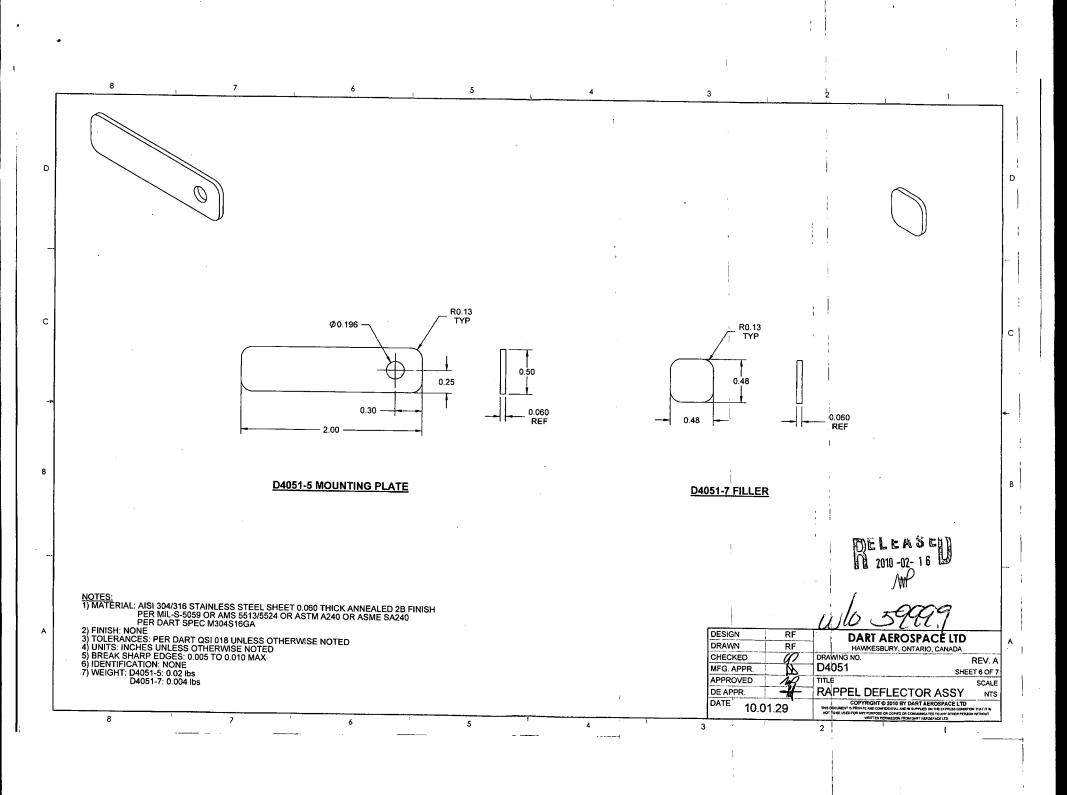
D4051-3F FLAT PATTERN

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

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DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF_	HAWKESBURY, ONTARIO, CANADA					
CHECKED	(P)	DRAWING NO. REV. A					
MFG. APPR.	77	D4051 SHEET 5 OF 7					
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W/O:										
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0.30 P/N D4051-93 - 0.05

D4051-9 PLACARD

NOTES:
1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

6

DESIGN RF DRAWN RF DRAWING NO. D4051

DART AEROSPACE LTD

CHECKED MFG. APPR. APPROVED DE APPR.

TITLE

10.01.29

HAWKESBURY, ONTARIO, CANADA

REV. A SHEET 7 OF 7 SCALE

RAPPEL DEFLECTOR ASSY

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